

Date: Wednesday, 4/4/2007 8:57:29 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	R44 BEARPAW
Job Number	31589A	Part Number	D35291
Estimate Number	12480	Drawing Number	D3529 REV A
P.O. Number	N/A	Project Number	N/A
This Issue	4/4/2007	S.O. No.	N/A
Prsht Rev.	NC	Type	MACHINED PARTS
First Issue	N/A	Material	N/A
Previous Run	30634	Due Date	4/20/2007
Written By		Qty:	17
Checked & Approved By	07.04.04	Um:	Each
Comment	Est Rev A New Issue 06-06-28 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MUHMWB10	UHMW 1" Black
Comment: Qty.: 1.2796 sf(s)/Unit Total : 25.5927 sf(s) Pick: blank: 13.5" x 13.000" x 1.00" thick (+0.030/-0.000) Material: Black UHMW 1"(MUHMWB10) Batch: M163975 34		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA645 and Dwg D3529 3-Deburr 34		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 34		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 34		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>PPP</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: R44 BEARPAW

Job Number: 31589A

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



34

Comment: FINAL INSPECTION/W/O RELEASE

4/07/04/16

Job Completion



U 820-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

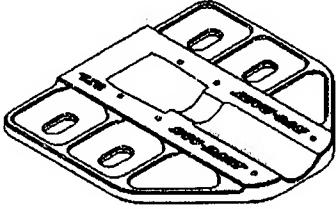
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

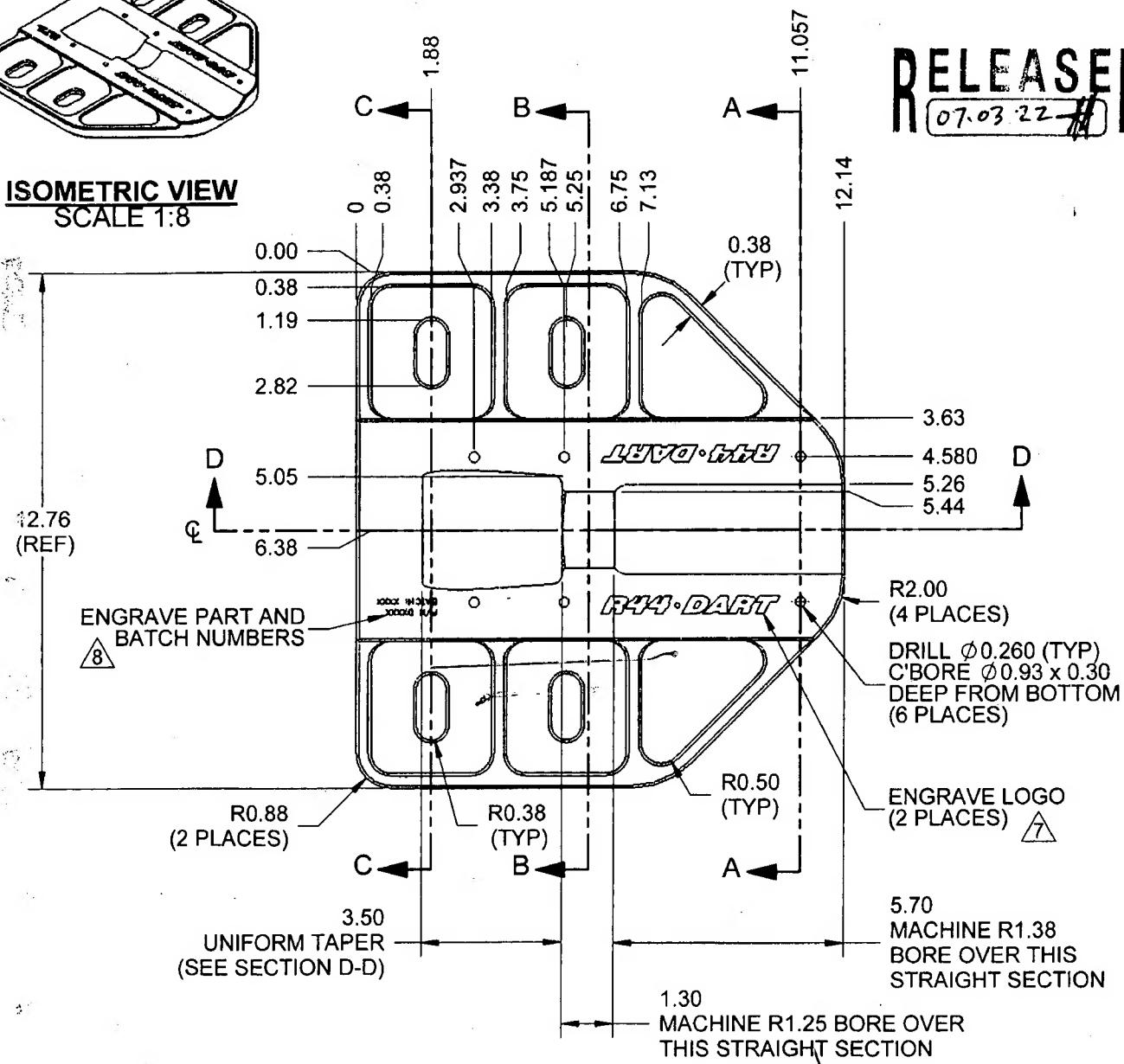


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CB</i>	APPROVED <i>CB</i>	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

REV	DATE	DESCRIPTION
A	07.01.04	NEW ISSUE



ISOMETRIC VIEW
SCALE 1:8



RELEASED
07.03.22

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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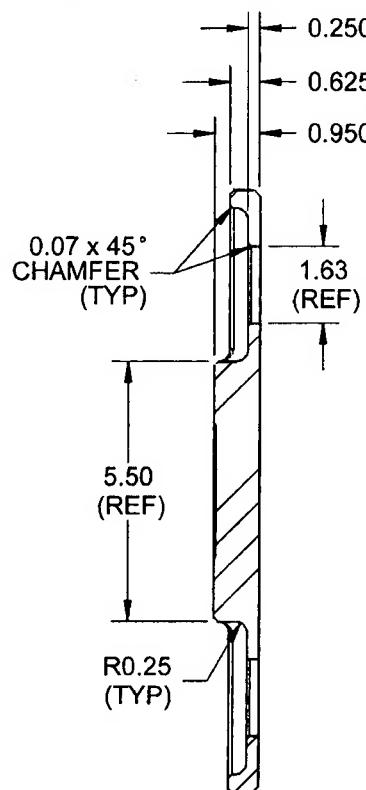
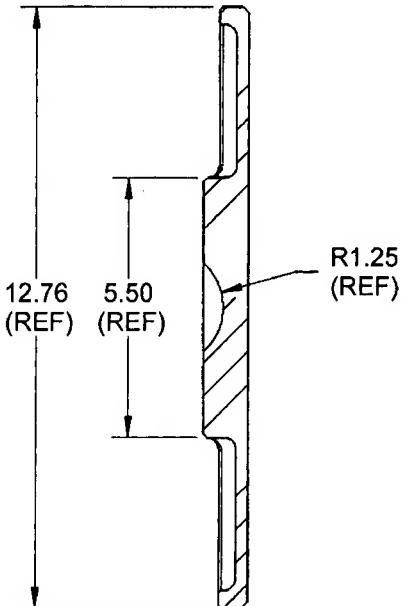
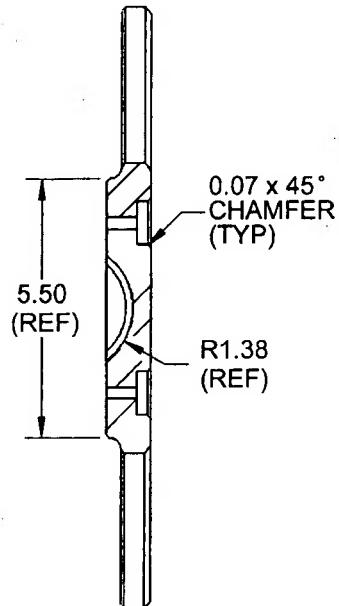
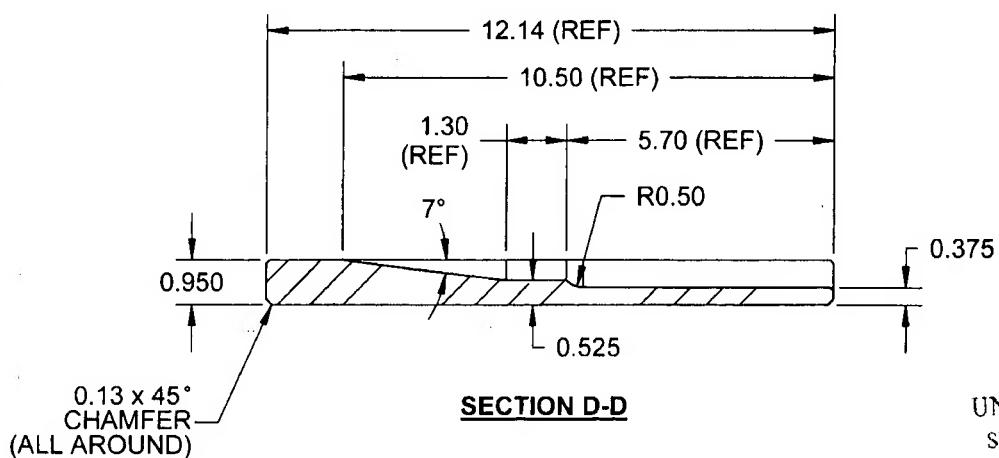
WORK ORDER
NO 31589A

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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AB</i>	APPROVED <i>AB</i>	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04	TITLE R44 BEARPAW	SCALE 1:4	

RELEASED
07.03.22**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D**

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DART AEROSPACE LTD

Work Order:

31589A

Description: Bearpaw

Part Number:

D3529-1

Inspection Dwg: D3529 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 5.50	± .030	5.503	—			
B 0.07X45°	± .030	0.051X45°	—			
C R0.25	± .030	R0.250	—			
D 0.250	± .010	0.242	—			
E 0.625	± .010	0.617	—			
F 0.950	± .010	0.951	—			
G 1.63	± .030	1.620	—			
H 12.14	± .030	12.140	—			
I 10.50	± .030	10.530	—			
J 5.70	± .030	5.730	—			
K 0.375	± .010	0.373	—			
L 0.525	± .010	0.523	—			
M 0.13X45°	± .030	0.121X45°	—			
N R0.500	± .030	R0.500	—			
O 12.76	± .030	12.760	—			
P 2.937	± .010	2.939	—			
Q 5.187	± .010	5.191	—			
R 0.38	± .030	0.380	—			
S 11.057	± .010	11.060	—			
T R0.260	± .006 - .001	R0.260	—			
U 0.30	± .030	0.309	—			
V R0.93	± .030	R0.928	—			
W 1.30	± .030	1.281	—			
X						
Y						

Measured by: *Gmk*
Date: 07/04/05

Audited by: *J.L.*
Date: 07/04/05

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	